

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012442**Date Inspected:** 06-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

6CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 169 located at SS18-PP046 on the cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WR10770 repair procedure.

6BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at CA027 on the counter weight side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WR10754 repair procedure.

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6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at CA029 on the counter weight side of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR10753 repair procedure.

Y Location of repairs areas by above noted welder (037743) is located at 750mm~1020mm.

NDT Observation

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

6AW

1. Deck plat stiffeners (various) to edge plate cjp welds located on the crossbeam side of segment between panel points 38~40.

6AE

1. Deck plat stiffeners (various) to edge plate cjp welds located on the crossbeam side of segment between panel points 38~40.

5CW

1. Longitudinal diagram vertical stiffener to horizontal stiffener cjp weld joint on web located at panel point 36 counter weight side of segment.

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations are as followed:

6AW

1. Floor beam flange to deck plate diaphragm (both sides) located panel point 39 and 40.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

5AW

1. Installation of cable trays in segment.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
